
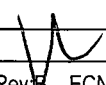
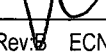


Date: Wednesday, 12/03/2008 2:15:51 PM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : TOP PANEL ASS'Y	
<b>Job Number</b> : 37911		
<b>Estimate Number</b> : 13135		
<b>P.O. Number</b> :	<b>Part Number</b> : D365011	
<b>This Issue</b> : 12/03/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3650 REV.B U/R	
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A	
<b>First Issue</b> : / / <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b> : B U/R	
<b>Previous Run</b> :	<b>Material</b> :	
<b>Written By</b> : 	<b>Due Date</b> : 19/03/2008	<b>Qty:</b> 2 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : 		
<b>Comment</b> : Est Rev.B ECN 1113P 08-01-22 DD		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
----------------	------------------------------	----------------------

1.0	M304S26GA	304/316 0.018 SHEET
-----	-----------	---------------------




**Comment:** Qty.: 0.0193 sf(s)/Unit Total: 0.0193 sf(s)  
 304/316 SS sheet 26 ga (0.018" thick)  
 Batch: M105519

SA 08/02/12

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



**Comment:** FLOW WATER JET  
 1-Cut as per Dwg D3650  
 Dwg Rev: \_\_\_\_\_  
 Prog Rev: \_\_\_\_\_  
 2-Deburr if necessary

cut by hand  


3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

SA 08-03-12 (2)

4.0	QC8	SECOND CHECK
-----	-----	--------------

**Comment:** SECOND CHECK**ENGINEERING APPROVAL**  


SA 08-03-12 (2)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------

**Comment:** Bend as per dwg D3650

SA 08/03/12 (2)

Date: Wednesday, 12/03/2008 2:15:51 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TOP PANEL ASSY

Job Number: 37911

Part Number: D365011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*08-03-12 (2)*

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and stock

Location: *WS*

*08-03-13 (2)*

8.0

QC21

FINAL INSPECTION/W/O RELEASE



*(2)*

Comment: FINAL INSPECTION/W/O RELEASE

*08/03/13*

Job Completion

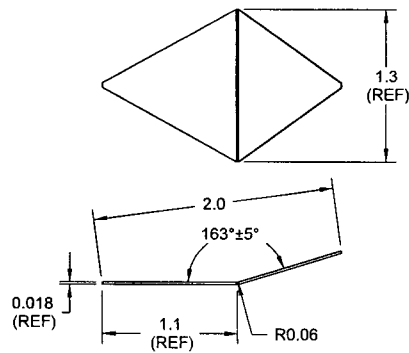


*mi 2008/3/13 (2)*

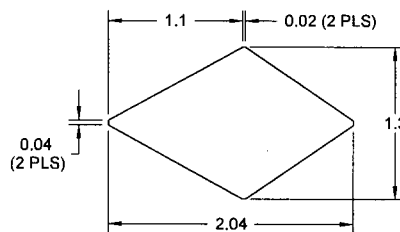
POSITIVE RECALL

EFFECTIVE *08-03-12* AUTH *AD*

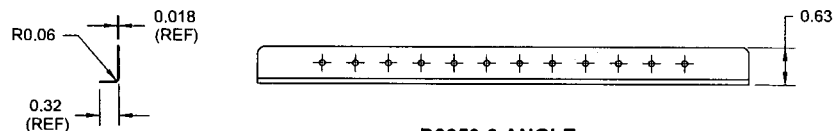
RELEASED *08-03-12* DATE *08-03-12*



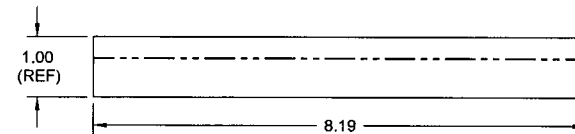
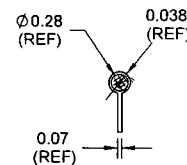
**D3650-11 FILLER PLATE**  
(MAKE FROM D3650-11F FLAT PATTERN)  
(SCALE 1:1)



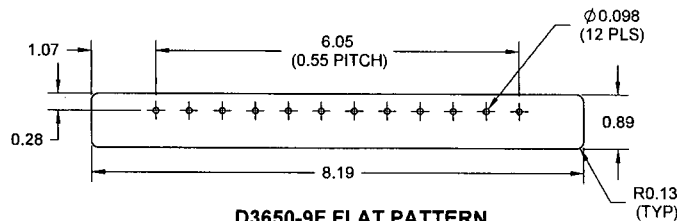
**D3650-11F FLAT PATTERN**  
(SCALE 1:1)



**D3650-9 ANGLE**  
(MAKE FROM D3650-9F FLAT PATTERN)



**D3650-7-8.19 SEAL**



**D3650-9F FLAT PATTERN**

**D3650-7-8.19 NOTES:**

- 1) MATERIAL: P/N 8168-1 TADPOLE SEAL (REF. BELL P/N 120-104-1)  
POSSIBLE SUPPLIER: EAGLE COPTERS OR BELL
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.05 lb
- 8) PART NUMBER: D3650-7-X.XX  
WHERE X.XX = LENGTH IN INCHES  
EG. 12.50" LONG = D3650-7-12.50

**D3650-9 & D3650-11 NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET,  
PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) D3650-9 WEIGHT: 0.05 lb  
D3650-11 WEIGHT: 0.007 lb

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3650	SHEET 9 OF 9
APPROVED		TITLE	SCALE
DE APPR.		TOP PANEL ASSEMBLY	1:2
DATE	08.01.07	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	